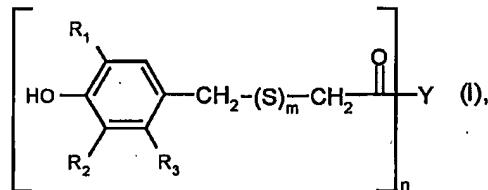
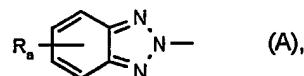


What is claimed is:

1. A method of producing low-dust granules of polymer additives or polymer additive mixtures, wherein the granule-forming polymer additives are mixed together, the mixture is converted into a workable mass and pressed through an orifice, and the pre-shaped strand-like extruded mass is cooled and, while still in a workable state, formed into granules by rolling, impressing, cooling and comminuting.
- 5 2. A method according to claim 1, wherein there are mixed together as granule-forming polymer additives phenolic polymer additives of formula:



10 wherein, independently of one another, one of R_1 and R_2 is hydrogen, a substituent selected from the group $\text{C}_1\text{-C}_{18}\text{alkyl}$, phenyl, $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl}$, phenyl- $\text{C}_1\text{-C}_3\text{alkyl}$, $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl-C}_1\text{-C}_3\text{alkyl}$, $\text{C}_5\text{-C}_{12}\text{cycloalkyl}$ and $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{C}_5\text{-C}_{12}\text{cycloalkyl}$ or a group of partial formula



15 wherein R_a is hydrogen or a substituent selected from the group $\text{C}_1\text{-C}_4\text{alkyl}$, halogen and sulfo;

and the other is a substituent selected from the group $\text{C}_1\text{-C}_{18}\text{alkyl}$, phenyl, $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl}$, phenyl- $\text{C}_1\text{-C}_3\text{alkyl}$, $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl-C}_1\text{-C}_3\text{alkyl}$, $\text{C}_5\text{-C}_{12}\text{cycloalkyl}$ and $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{C}_5\text{-C}_{12}\text{cycloalkyl}$ or a group of partial formula (A)

20 wherein R_a is as defined;

R_3 is hydrogen or methyl;

m is the number zero or 1; and

n is an integer from 1 to 4; wherein,

when n is the number 1,

25 m is zero or 1 and Y denotes

a monovalent substituent $-O-Y_1$ or $-N(-Y_2)_2$, wherein

Y_1 is C_5-C_{45} alkyl, C_3-C_{45} alkyl interrupted by at least one oxygen atom, C_5-C_{12} cycloalkyl, C_2-C_{12} alkenyl,

a substituent of partial formula



wherein R_b is hydrogen, C_1-C_6 alkyl, C_3-C_5 alkenyl or benzyl,

a substituent of partial formula



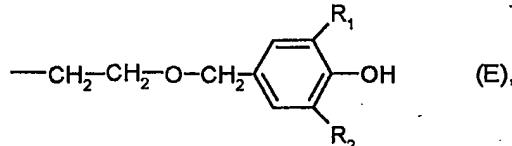
wherein R_c is hydrogen, C_1-C_{24} alkyl, C_5-C_{12} cycloalkyl or phenyl,

10 a substituent of partial formula



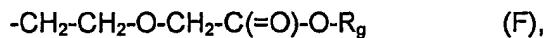
wherein one of R_d and R_e is hydrogen or methyl and the other is methyl, and R_f is hydrogen or C_1-C_{24} alkyl,

a substituent of partial formula



wherein R_1 and R_2 are as defined above,

or a substituent of partial formula

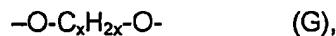


wherein R_g is hydrogen or C_1-C_{24} alkyl; and

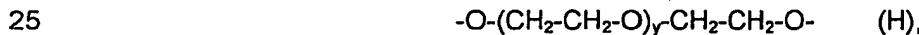
20 Y_2 is hydroxy- C_2-C_4 alkyl; or,

when n is the number 2,

m is zero and Y is a bivalent group of partial formula

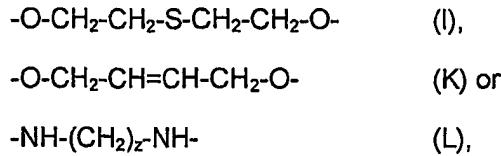


wherein x is an integer from 2 to 20,



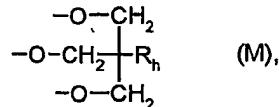
wherein y is an integer from 1 to 30,

- 27 -

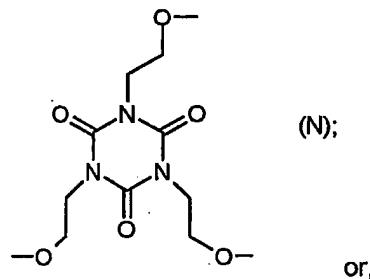


wherein z is zero or an integer from two to ten; or,

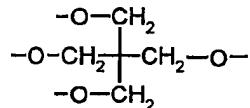
5 when n is the number 3, m is zero and Y is a trivalent group of partial formula



wherein R_h is C_1-C_{24} alkyl or phenyl, or

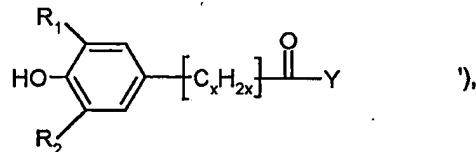


when n is the number 4, m is zero and Y is the tetravalent group of partial formula



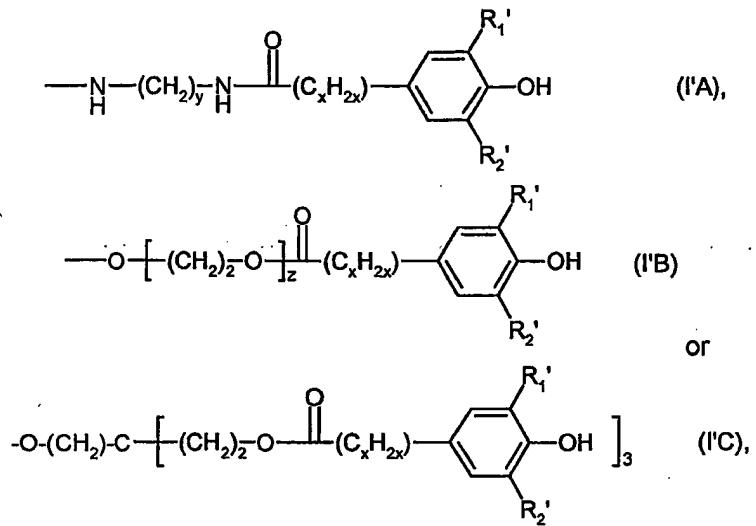
10

3. A method according to claim 1, wherein there are mixed together as granule-forming polymer additives phenolic polymer additives of formula:



wherein, independently of one another, one of R_1 and R_2 is hydrogen or C_1-C_4 alkyl and the other is C_3-C_4 alkyl; x is zero (direct bond) or an integer from one to three; and Y is C_8-C_{22} alkoxy or a group of partial formula

15



wherein, independently of one another, one of R'_1 and R'_2 is hydrogen or $\text{C}_1\text{-C}_4$ alkyl and the other is $\text{C}_3\text{-C}_4$ alkyl; x is zero (direct bond) or an integer from one to three; y is an integer from two to ten and z is an integer from two to six.

- 5 4. A method according to claim 1, wherein the mixture of granule-forming polymer additives is converted into a workable mass in a heatable ko-kneader.
- 10 5. A method according to claim 1, wherein the workable mass is extruded from the ko-kneader through a circular nozzle or slot-shaped nozzle and the pre-shaped, strand-like mass is subjected to further processing.
- 15 6. A method according to claim 1, wherein the plastic, pre-shaped mass is processed by squeeze rollers having a smooth and polished surface and then shaping rollers provided with embossing lines.
7. A method according to claim 1, wherein the shaping rollers are provided with grooves.
- 18 8. A method according to claim 1, wherein the transport and the cooling and solidification are carried out on a continuous steel belt.
9. A method according to claim 1, wherein the components of the granule-forming polymer additives are fed into the ko-kneader in liquid or solid form or in molten form.
- 20 10. A method according to claim 1, wherein the impressed product mat is comminuted to granule size in a sieve granulator.